

Work Order ID 82289-2

March-28-12 12:54:56 PM

82289

Page 1

Item ID: D4436-043

Revision ID:

Item Name: All Outboard Bracket Assembly

Start Date: 28/03/2012 Start Qty: 6.00

Required Date: 11/04/2012 Req'd Qty: 6.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLC

QC:

Date: 12/03/28 Tooling:

Date: SPC (Y/N):

Date:

Run Start *NR1*

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

Draw Nbr

Revision Nbr

D4436

A

100

100

Waterjet

FLOW CNC Waterjet

QC1 - OK

FLOW WATER JET

0.00

Memo

1-Cut D4436-1 as per Dwg

Dwg Rev: FA

Prog Rev: A

0.00

2-Deburr if necessary

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

12-4-30

12-4-30

Work Order ID 82289

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Page 2

Item ID: D4436-043

Revision ID:

Item Name: Aft Outboard Bracket Assembly

Start Date: 28/03/2012 Start Qty: 6.00

Required Date: 11/04/2012 Req'd Qty: 6.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.00

Sidley

(76)

130

Bend as per dwg

0.00

130

Brake NC

Brake NC

Memo

0.00

(C)

12/25/12

140

0.00

140

Small Fab

Small Fab

Memo

0.00

C"SINK AS PER DWG

6x Ø

12/05/12

Work Order ID 82289

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82289

Page 3

Item ID: D4436-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Outboard Bracket Assembly

Start Date: 28/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/04/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

160

Chemical Conversion Coat per QSI005-4.1

0.00

160

Hand Finish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

(46)

(6)

16712.5-2

6

4

16712.5-2

Work Order ID 82289

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Page 4

Item ID: D4436-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: All Outboard Bracket Assembly

Stop ***NS2***

Start Date: 28/03/2012 Start Qty: 6.00

6

Required Date: 11/04/2012 Req'd Qty: 6.00

6

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

180

0.00

180

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg. do not install rubber seal.

185

QC5- Inspect part completeness to step on W/O

0.00

185

QC

Memo

0.00

Quality Control

190

Black Sandtex(Ref 4.3.5.7) per QSI005 4.3

0.00

190

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:30

7:42

4:00

4:00

MU7333

EX

GH
12/05/08

(C)

12/05/08

EX

EX

12/05/08

12/05/08

Work Order ID 82289

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Item ID: D4436-043
 Revision ID:
 Item Name: Aft Outboard Bracket Assembly
 Start Date: 28/03/2012 Start Qty: 6.00
 Required Date: 11/04/2012 Req'd Qty: 6.00
 Reference:

Accept

N9000040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: Date: Tooling: Date:
 QC: Date: SPC (Y/N):

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/
 Work Center ID

Operation
 Description

Set Up/
 Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

202

0.00

202

Small Fab

Memo

0.00

Small Fab

Install rubber seal as per dwg

3M 1300 batch: 1720-1300

205

QC5- Inspect part completeness to step on W/O

0.00

205

QC

Memo

0.00

Quality Control

(2)

FF
 12-06-13

①

SP
 12/06/13

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Page 6

Item ID: D4436-043
 Revision ID:
 Item Name: Aft Outboard Bracket Assembly
 Start Date: 28/03/2012 Start Qty: 6.00
 Required Date: 11/04/2012 Req'd Qty: 6.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: Date:
 QC: Date:

Tooling: Date:
 SPC (Y/N): Date:

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/
 Work Center ID

Operation
 Description

Set Up/
 Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
 Code Qty Qty Number Stamp

210 Identify as per dwg & Stock Location **GA**

0.00

210

Packaging Memo

0.00

Packaging

220 QC21-Final Inspection - Work Order Release

0.00

220

QC Memo

0.00

Quality Control

(2)

12/6/13

12/6/14

MF
 12-06-13

Picklist Print

March-28-12 12:55:03 PM

Page 1

Work Order ID: 82289

82289

Parent Item: D4436-043

D4436-043

Parent Item Name: All Outboard Bracket Assembly

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD
12.01.24 PER DWG REV.A DD VERIFIED

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040

Purchased

No

100

sf

452.5000

1.59

10.04211

M6061T6S 040

**

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

452.5

121030

164.5

121099

288

MS20426AD3-2

Purchased

No

180

Each

18,319.00

4

24 101

MS20426AD3-2

**

Rivet

Location

Loc Qty

Loc Code

Mezz

18319

1173

8919

13276

9400

MS21075L08

Purchased

No

180

Each

249.0000

2

12

MS21075L 08

**

ANCHOR NUT

Location

Loc Qty

Loc Code

ST303

219

111578

2

120560

217

ST308

30

120930

30

317
32 4-30
12/05/08
11/2/011 (24x)
12/05/08
12

Picklist Print

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Page 2

Work Order ID: 82289

82289

Parent Item: D4436-043

D4436-043

Parent Item Name: All Outboard Bracket Assembly

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 6.00

Required Qty: 6.00

D4441-1

Manufactured No

202 0

182.6290 1.408 8.448

D4441-1

**

Rubber Seal

Location

Loc Qty

Loc Code

prelim	6.739
74760	6.739
ST413	175.89
79385	165.99
80763	9.9

2.816

FF 12-06-13

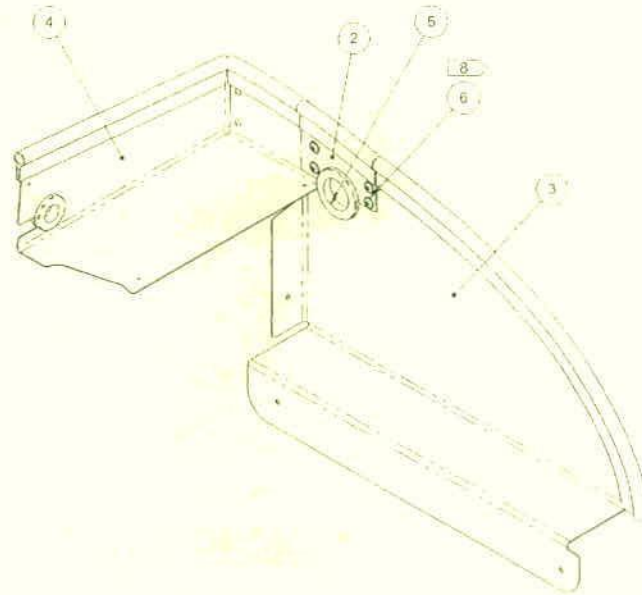
cut qty 1 to 16.00"

March-28-12 12:55:03 PM

Shop Packet Print

Page 2

ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4436-041	AFT BRACKET ASSEMBLY
2	1	D4435-043	BRACKET ASSEMBLY
3	1	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
4	1	D4436-045	AFT INBOARD BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	4	AN525-832R6	SCREW



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 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 DATE 12/03/28

2228941
 12/03/28

D4436-041 AFT BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.31 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

REV	NEW ISSUE	DESCRIPTION	RF	DATE
DESIGN	RF			
DRAWN	RF			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	12.01.17			

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4436 REV. A
 SHEET 1 OF 2

TITLE COVER ASSEMBLY SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

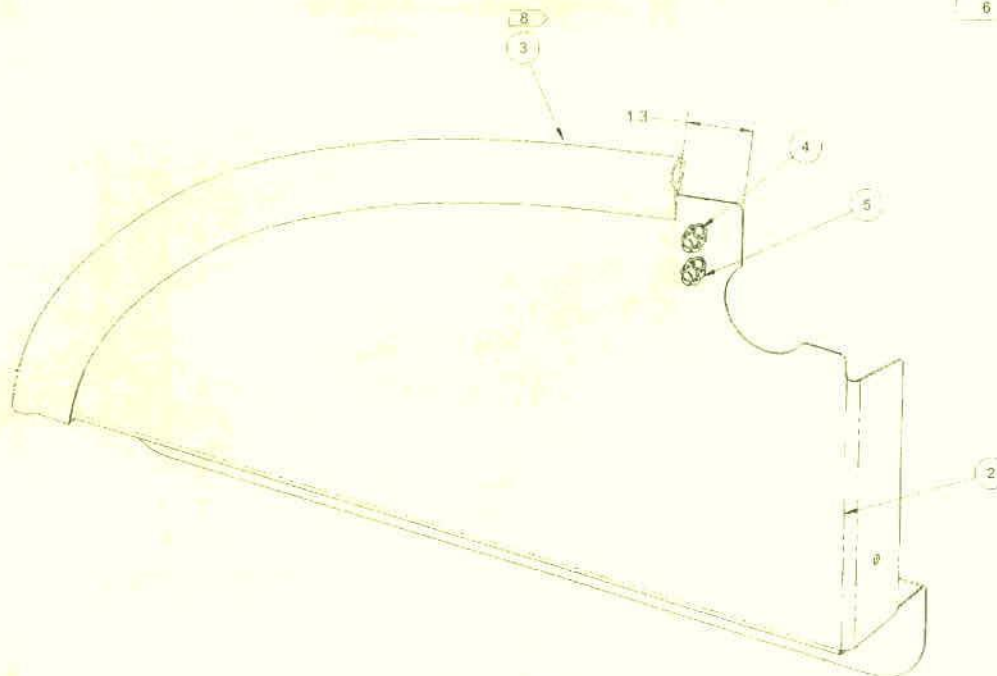
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
2	1	D4436-1	BRACKET
3	1	D4436-1-160	RUBBER SEAL
4	4	MS2-426AD3-2	RIVET
5	2	MS2075L08	NUT PLATE
6	A/R	3M 1300/1300L	ADHESIVE



D4436-043 AFT OUTBOARD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3 MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL. IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

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MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 7	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

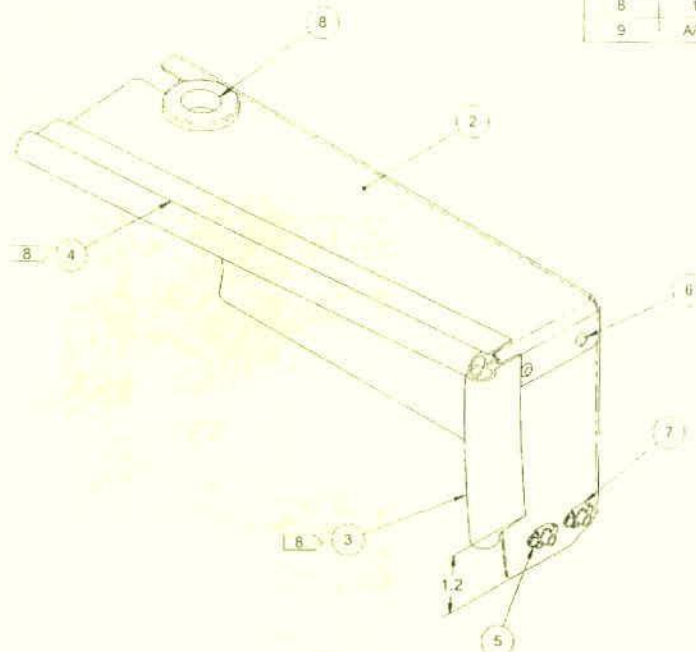
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4436-045	AFT INBOARD BRACKET ASSEMBLY
2	1	D4436-3	BRACKET
3	1	D4441-1-03B	RUBBER SEAL
4	1	D4441-1-10C	RUBBER SEAL
5	4	MS20426AD-2	RIVET
6	2	MS20470AD-3	RIVET
7	2	MS21075LD-8	NUT PLATE
8	1	MS35489-19	GROMMET
9	A/R	3M 1300/1305L	ADHESIVE



D4436-045 AFT INBOARD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005.4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1305L ADHESIVE,
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL,
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

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CHECKED	RF	DRAWING NO	REV. A
MFG. APPR.	RF	D4436	SHEET 3 OF 7
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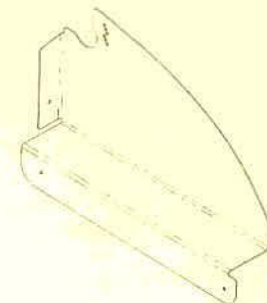
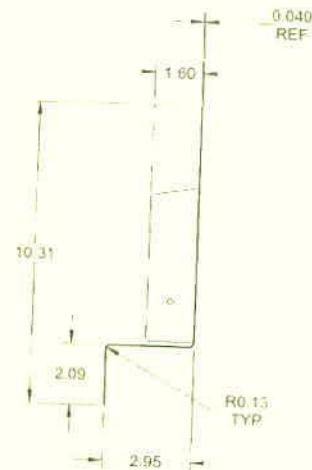
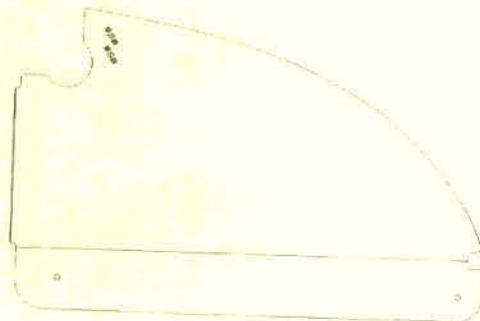
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



82281

D4436-1 BRACKET

RELEASED
2012-01-23

NOTES:

- 1) MATERIAL: MAKE FROM D4436-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

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MFG. APPR.	<i>[Signature]</i>		TITLE COVER ASSEMBLY	SHEET 4 OF 7 SCALE NTS
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DE APPR.	<i>[Signature]</i>			
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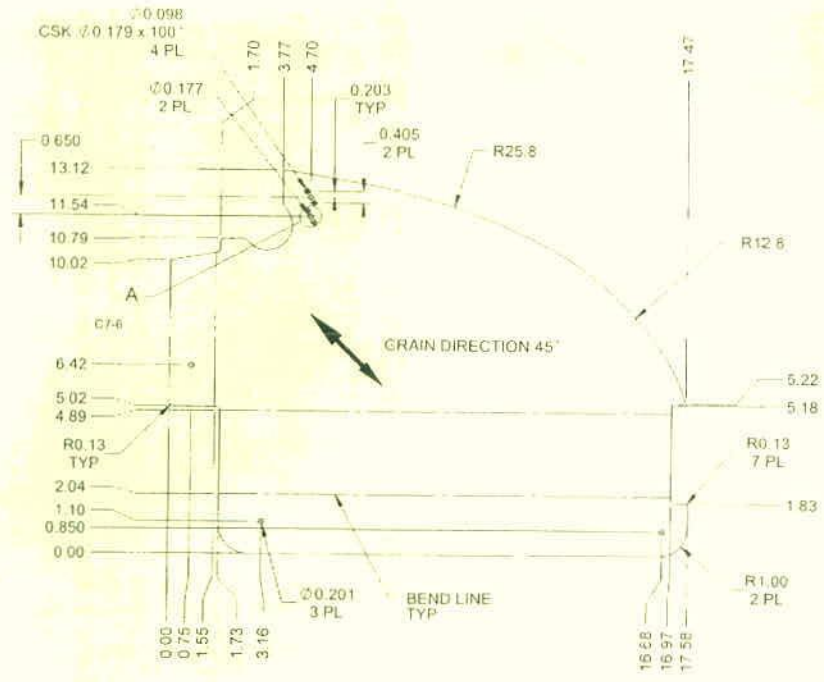
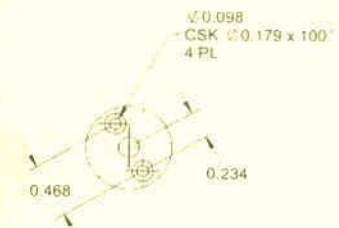
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4436-1F FLAT PATTERN

82289

RELEASED
2012-07-23

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

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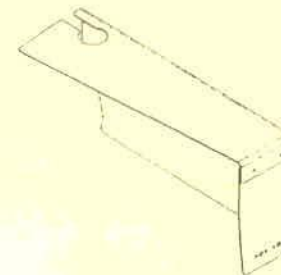
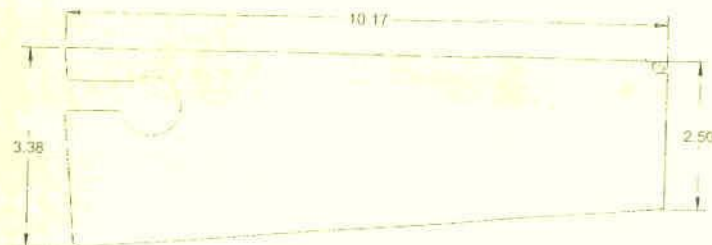
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

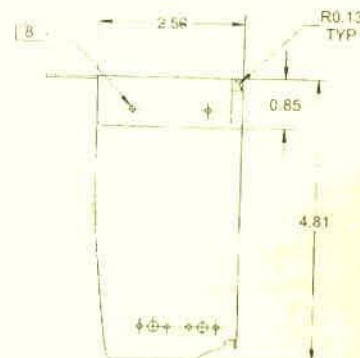
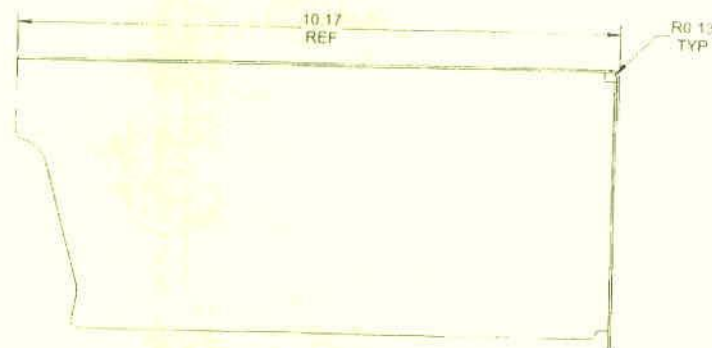
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



82289



D4436-3 BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D4436-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs
- 8) TRANSFER Ø0.129 HOLES THRU 2 PLACES

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4436	SHEET 6 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER ASSEMBLY	NTS
DATE	12.01.17	<small> COPYRIGHT © 2012 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. NO PART OF THIS PUBLICATION MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD. </small>	

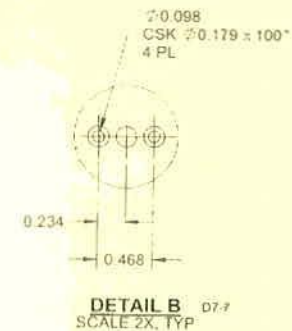
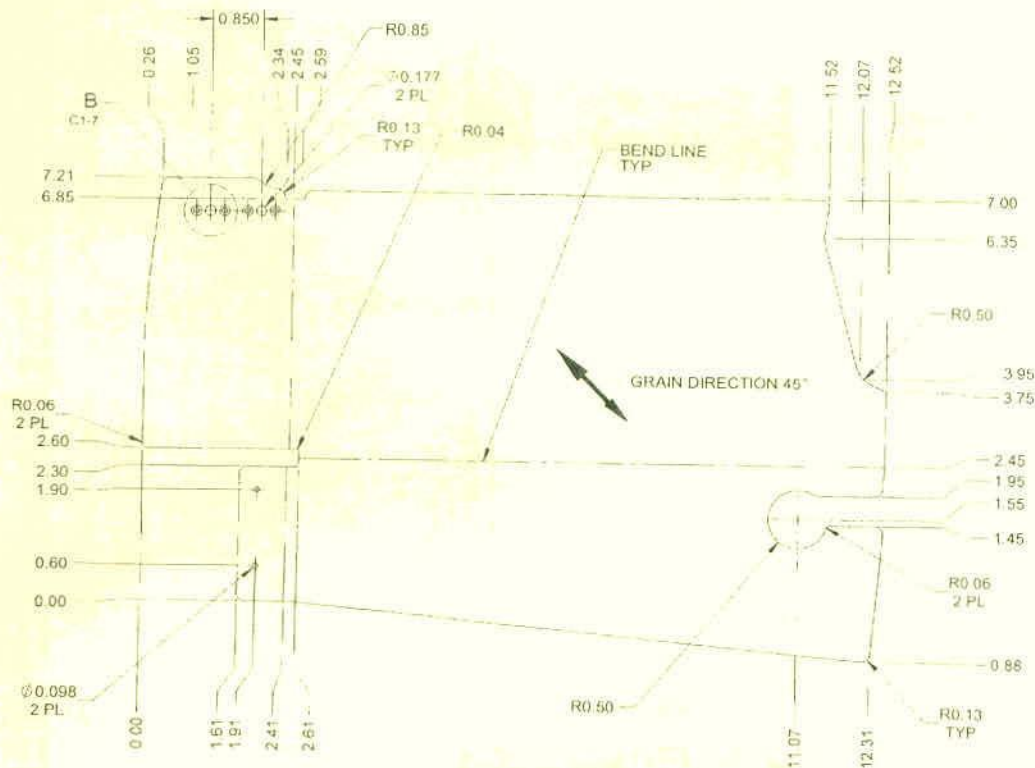
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4436-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QS. 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4436	SHEET 7 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	COVER ASSEMBLY	NTS
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